

*Blue*

Date: Wednesday, 03/09/2008 10:25:57 AM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> :	41718	<b>Part Number</b> :	D29382
<b>Estimate Number</b> :	10939	<b>Drawing Number</b> :	D2938 REV C - BLUE
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	03/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	C
<b>First Issue</b> :	/ /	<b>Type</b> :	MACHINED PARTS
<b>Previous Run</b> :	41131	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	26/09/2008
<b>Checked &amp; Approved By</b> :	<i>JLD 08.9.03</i>	<b>Qty:</b>	4
<b>Comment</b> :	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: *533792 ml 2/10/10*

*(4)*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

*ml 2/10/10 08/09/12*

*(4)*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*ml 2/10/10 08/09/12*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

*ml 2/10/10 08/09/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:58 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41718

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/09/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YJ

08-09-12

(X4)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B106729

B105918

B105917

> ml 08 09 24 (4)

(PW)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-09-25

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

5/9/25

(X4)

SCF

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 JH

Job Completion



U 08/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/09/26  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41718</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-09-24</u>	<u>7.0</u>	Primer is slightly visible on all the corners, and edges of the saddles.  R.C: Primer is lighter than the base in color.	<u>[Signature]</u> <u>08/09/24</u>	scuff and re-paint per 051005.  Next order, grey primer will be used.	<u>[Signature]</u> <u>08/09/24</u>	<u>[Signature]</u> <u>08/09/25</u>	<u>[Signature]</u> <u>08/09/24</u>	<u>[Signature]</u> <u>08/09/24</u>

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41718
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

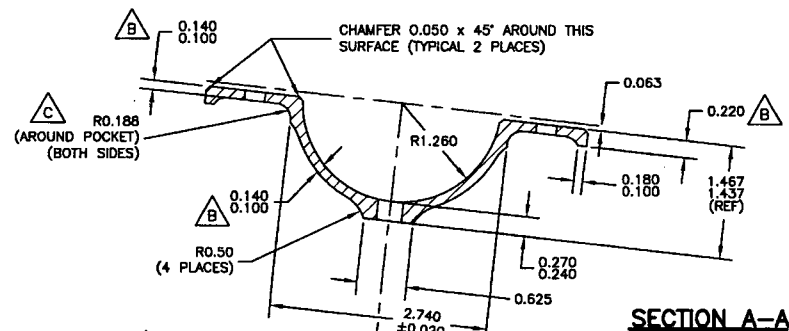
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.130	.135	.135		
B	0.100	0.140		.130	.130	.130	.135		
C	0.100	0.140		.120	.125	.126	.128		
D	0.210	0.230		.226	.225	.227	.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.506	2.500	2.500	2.500		
H	0.510	0.515		.511	.510	.510	.510		
I	1.572	1.582		1.575	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.258	.258	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.112	.110	.110	.110		
O	0.540	0.560		.548	.547	.546	.553		
P	0.490	0.510		.501	.500	.500	.500		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.258	.257	.262	.262		
T	0.100	0.180		.135	.135	.135	.131		
U	1.625	1.635		1.627	1.627	1.627	1.627		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.257	1.257	1.257	1.257		
Y	1.565	1.585		1.571	1.571	1.571	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

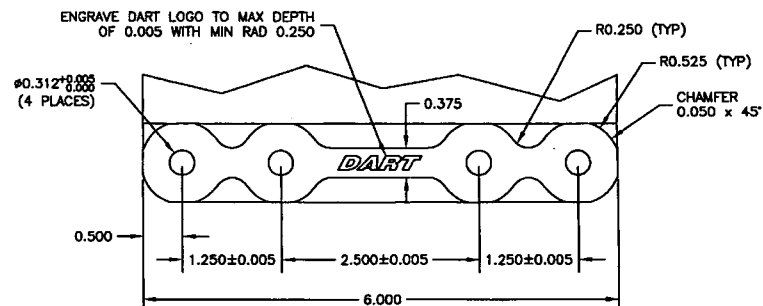
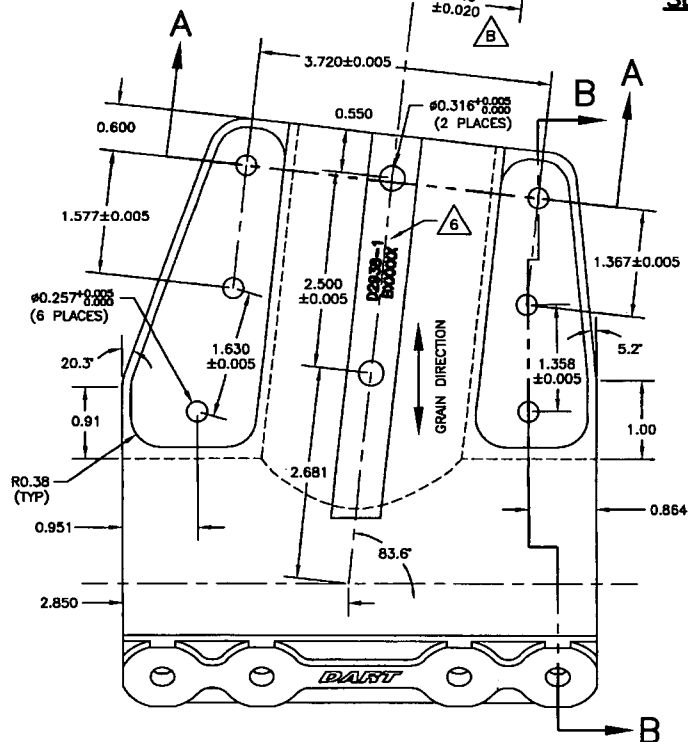
Measured by:	one 188
Date:	08/09/11

Audited by:	JL
Date:	08/09/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

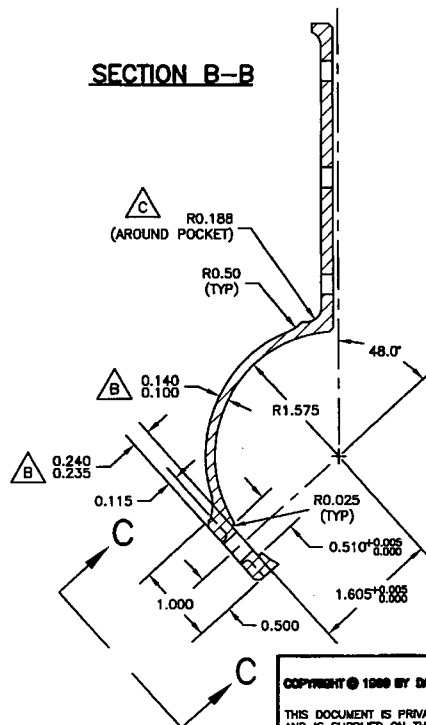


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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BELLINGHAM, WA

DRAWING NO. D2938  
REV. C  
SHEET 1 OF 1

SCALE  
2:3

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07.02.12